



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

269T1338-11-13
Job Sheet 172250



Part No: 269T1338-11-13

Job Qty: 2 ea

Part Name: Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 269T1338-11 Rev 4 IPP Rev A 18.02.12 New issue FK Verify DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/22/18	0.00	0.00	Start Up Machining		18/10/28
110	Mori Seiki	2 pcs		2/23/18	0.00	4.00	MORI NV5000-1		18/10/28
120	QC	2 pcs		2/23/18	0.00	0.00	QC2-2		18/10/28
130	QC	2 pcs		2/23/18	0.00	0.00	QC8		18-11-03
150	Outsource	2 pcs		2/23/18	0.00	0.00	Outsource4		18-11-5
160	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging2		NOV 08 2018
170	QC	2 pcs		2/23/18	0.00	0.00	QC6		38
180	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging3-1		9-88
190	QC21-SA	2 Ea		2/23/18	0.00	0.00	QC21		NOV 12 2018

Part Op 110 - 1-Machine as per folio FB 866 FOLIO REV: DWG REV: 9-88 Engrave part

Descriptions: number and batch number And T/N number 2-Deburr

150 - Issue P/O to ATG: P001593 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X1.750	6061T6 Bar 1.000 X 1.750	1.5420 ft (.771 ea)	90-Start up Operation	5094299 (1x) 5036062 (2x)
1.250x2.000	1.250x2.000			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X1.750	2	0	0

Part Specifications

Specifications could not be found.

Plex 2/14/18 1:22 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S122053



Part: 269T1338-11-13

Job No: 172250

Serial No/Batch: S122053

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 10/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

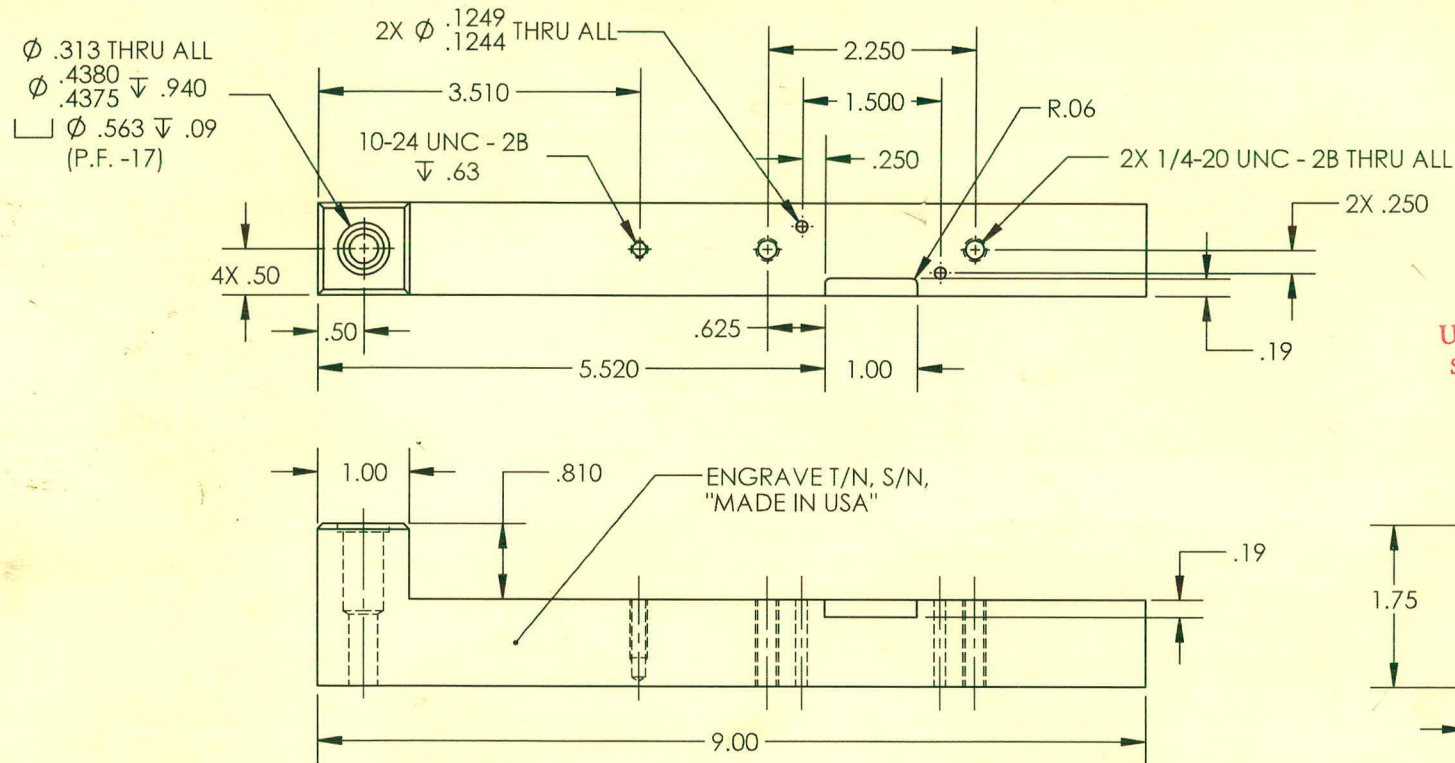
QA Closed: _____ Date: _____

Work Order update only ☐

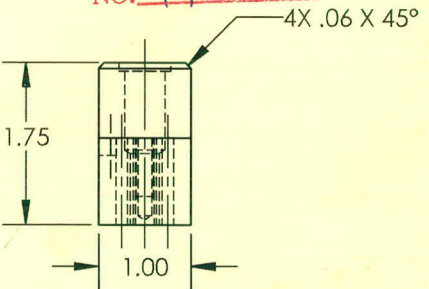
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-13 DELETED R.062 IN BOTTOM OF CUTOUT, ADDED MISSING DIM 2X R.06, CH'D DIM WAS 2X Ø.125 P.F. -23 IS 2X LIMITS Ø.1244 TO .1249.	5/22/2014	DPD	GE
4	17-0025	-13 CH'D DIM WAS Ø.313 THRU L L Ø.563 .094 S.F. -17 Ø.4380/.4375 .94 P.F. -17 IS Ø.313 THRU ALL Ø.4380/.4375 .94 L L Ø.563 .094 (P.F. -17), WAS 2X 1/4-20 UNC THRU IS 2X 1/4-20 UNC - 2B THRU ALL, WAS #10-24 UNC .63 IS 10-24 UNC - 2B .63; REMOVED DIM 6.020, 1.125, .50; ADDED DIM 5.520, .625, 1.500, .250.	1/30/2017	SM	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172250 18-02-14



(13)

BLOCK

DART AEROSPACE	
TITLE PITCH LINK RIGGING BLOCK ASSEMBLY	
DWG NO. 269T1338-11-13	REV 4
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/01/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/08/2017	USED ON MODEL
APPROVED: JAG 02/21/2017	SCHWEIZER, SEE NOTES
SCALE 1:2	DATE 8/15/2007
SHEET 2 OF 4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

DART AEROSPACE LTD		Work Order: 17.2250
Description: Block		Part Number: 26971328-K-12
Inspection Dwg:	Rev: 04	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.312	+0.005 -0.003 H-	0.315	✓		pin	
0.4375/0.4380		0.4375	✓		pin	
0.940	0.005 H-	0.944	✓		pin/MC 06	
0.563	+0.006 -0.005 H-	0.563	✓		MC 06	
0.090	0.010 H-	0.090	✓		MC 06	
10-24		20	✓		20/40 20	
0.63	0.010 H-	0.640	✓		MC 06	
3.510	0.005 H-	3.504	✓		MC 06	
0.1244/0.1249	H-	0.1245	✓		pin	
2.250	0.005 H-	2.246	✓		MC 06	
1.500	0.005 H-	1.500	✓		pin	
0.250	0.005 H-	0.250	✓		pin	
1/4-20		20	✓		20/40 20	
0.250	0.005 H-	0.250	✓		pin	
0.19	0.010 H-	0.191	✓		MC 06	
1.00	0.010 H-	1.003	✓		MC 06	
0.625	0.005 H-	0.625	✓		pin	
5.520	0.005 H-	5.516	✓		MC 06	
0.50	0.010 H-	0.495	✓		MC 06	
0.50 84	0.010 H-	0.501	✓		MC 06	
1.00	0.010 H-	0.997	✓		MC 06	
0.810	0.005 H-	0.809	✓		MC 06	
0.19	0.010 H-	0.190	✓		MC 06	
9.00	0.010 H-	8.995	✓		MC 06	
1.75	0.010 H-	1.751	✓		MC 06	
1.00	0.010 H-	1.002	✓		MC 06	
0.06X45	±0.010	0.058X45	✓		"	

Measured by: P.J.	Checked by: B.F.	QC Inspector:
Date: 18/10/28	Date: 18-11-03	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041593**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041593
PO Date: 11/5/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185757	D5237-3	Bracket : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2 Certification of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$13.50/pcs	\$108.00
Line Item Note ** NEED ASAP **											
	182752			Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$13.50/pcs	\$108.00
Sub Total:							16	0	16		\$216.00

Plex 11/7/18 9:57 AM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041593**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	172250	269T1338-11-13	Block -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/9/18	2 pcs	0 pcs	2 pcs	\$13.50/pcs	\$27.00
3	185546	646.9710	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	11/9/18	5 pcs	0 pcs	5 pcs	\$20.50/pcs	\$102.50
4	172252	269T1338-11-15	Locator -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/9/18	2 pcs	0 pcs	2 pcs	\$13.50/pcs	\$27.00
Grand Total:											\$372.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/7/18 9:57 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916451

Date: 07-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chris Jula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 2 each	Part: 269T1338-11-13 ✓ Block Anodize per MIL-A-8625F, Type II, Class 2, Black, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 24036	Rev: 4 PO: PO041593 ✓	Line: 3 DAS 38 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>7/4/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

